

Work Order ID 65883

Wednesday, January 26, 2011 1:54:15 PM



Page 1

Item ID:	D4274-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Plate, Fwd Support				Stop	
Start Date:	1/26/2011	Start Qty:	4.00			
Required Date:	2/4/2011	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:		Date:	11-01-26	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4274	Rev A Rev B	11.01.31							
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
110		0.00							
QC	Memo	0.00							
Quality Control									

B 11-2-2

6

H 11-2-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65883

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Wednesday, January 26, 2011 1:54:15 PM

Item ID: D4274-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Fwd Support

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



8/102/03

QC

Memo

0.00

Quality Control

(X6)

130

Identify as per dwg & Stock Location: 139

0.00



Packaging

Memo

0.00

Packaging

11/2/4

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/04

MF
11-02-04

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 1:54:21 PM

Page 1

Work Order ID: 65883

Parent Item: D4274-1

Parent Item Name: Plate, Fwd Support




Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	65.2003	0.357	1.503158	2.2	11-2-2	

Location

Loc Qty

Loc Code

MAT

65.2003

114799

0.5003

116437

0.7

116623

64

116623

(6)

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DART AEROSPACE LTD		Work Order: 65888
Description: PLATE FWD Support		Part Number: D4274-1
Inspection Dwg: D4274-1, Rev: B		Page 1 of 1

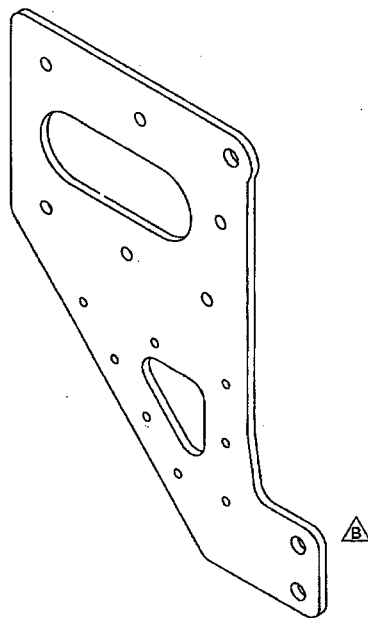
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

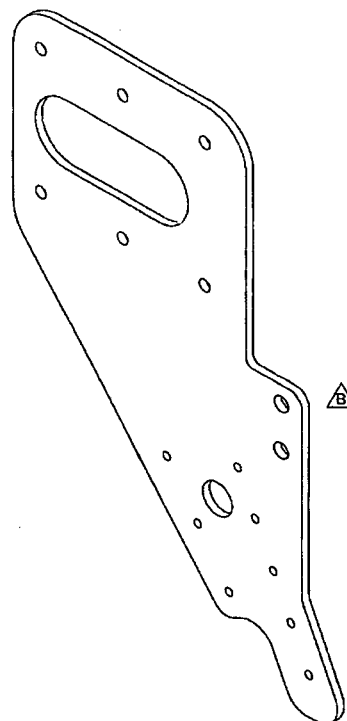
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 129	+ .005 - .001	131	✓		V 1302	
Ø 191	+ .005 - .001	192	✓		V	
Ø 257	+ .006 - .001	258	✓		V	
4.40	± .030	4.410	✓		V	
1.40	± .030	1.399	✓		V	
.335	± .010	.333	✓		V	
.750	± .010	.753	✓		V	
.380	± .010	.380	✓		V	
1.30	± .030	1.304	✓		V	
5.70	± .030	5.696	✓		V	
4.85	± .030	4.858	✓		V	
8.95 7.11	± .030	8.95 7.112	✓		V	
2.80	± .030	2.801	✓		V	
1.75	± .030	1.748	✓		V	
1.05	± .030	1.054	✓		V	
.303	± .010	.305	✓		V	
.375	± .010	.373	✓		V	
.90	± .030	.901	✓		V	
.75	± .030	.750	✓		V	
.25	± .030	.251	✓		V	
3.006	± .010	3.002	✓		V	
1.500	± .010	1.5001	✓		V	
2.300	± .010	2.297	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-2-2	Date: 11/02/03	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4274-1 PLATE, FWD SUPPORT



D4274-3 PLATE, AFT SUPPORT

SHOP COPY
RETURN TO,
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45883

PH-01-25

RELEASED
R 2010-06-06

B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS	SC	10.12.02
A	NEW ISSUE	SC	10.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLATES, BASKET SUPPORT	NTS
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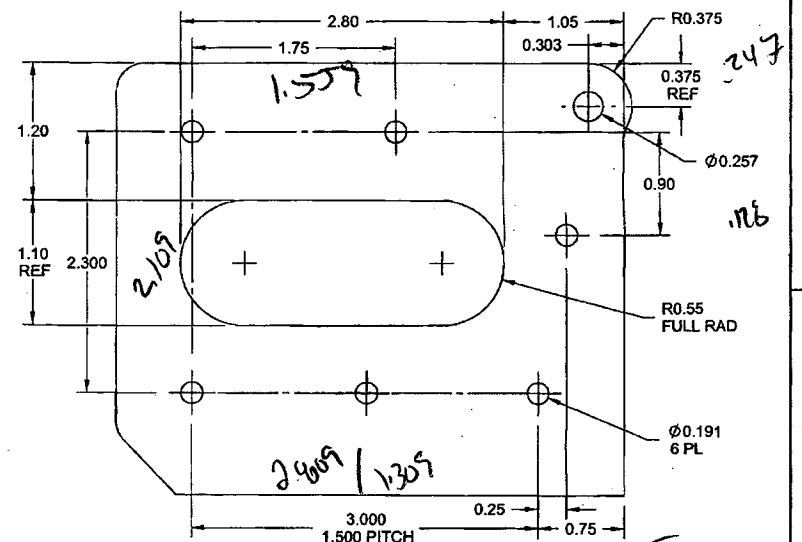
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DETAIL A (D6-2)

2.531
1.701

0.40

336

0.25

1.900
0.95 PITCH

1.771

0.821

0.76

0.889

RELEASE
2010-12-86

DETAIL B (B7-2)

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 2 OF 3
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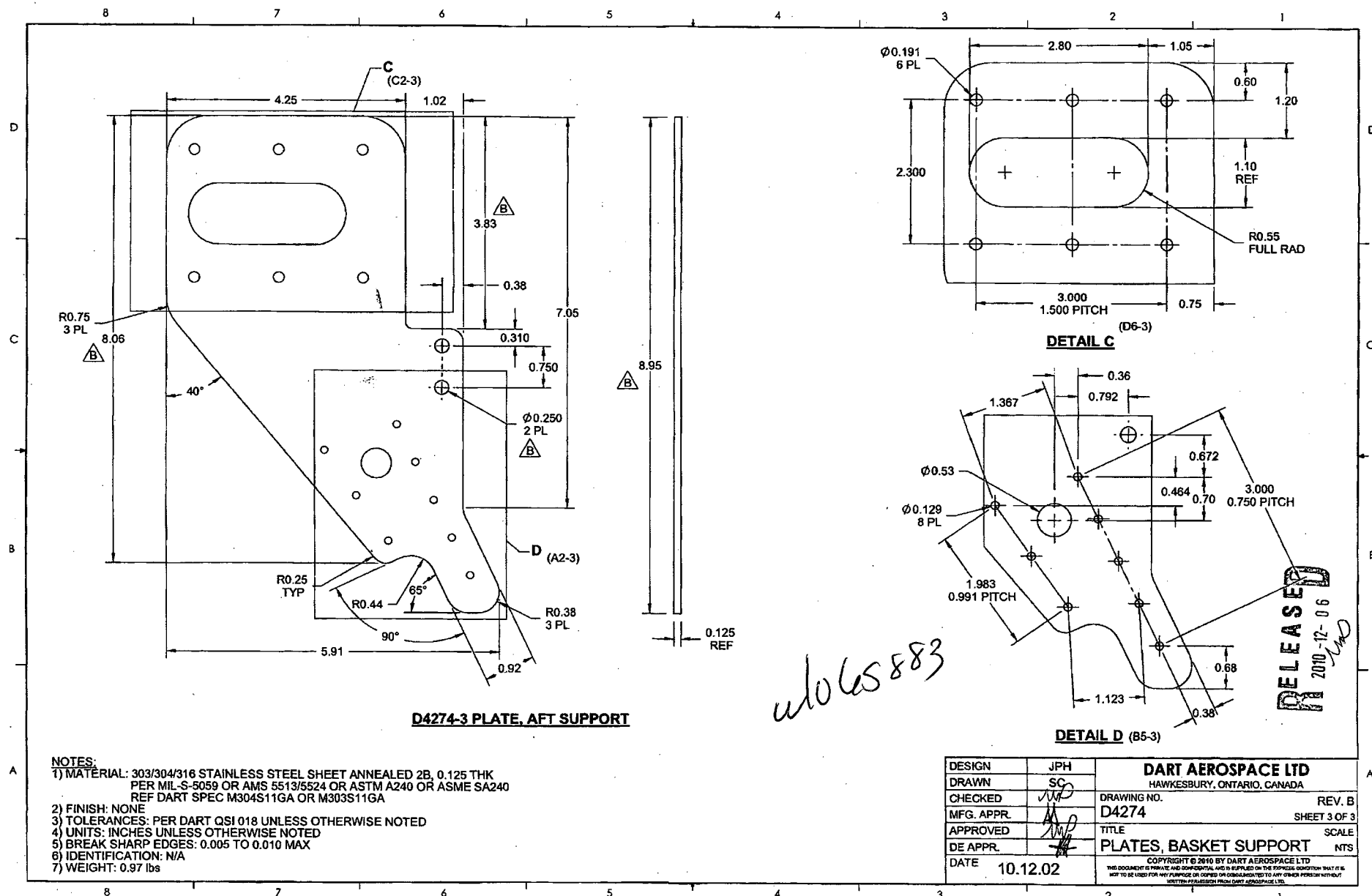
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CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4274	SHEET 3 OF 3
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DE APPR.	MP	PLATES, BASKET SUPPORT	NTS
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